

Work Order ID 72551-2

Friday, July 29, 2011 8:56:48 AM

SPLIT-2



Page 1

Item ID: D4034-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Upper Rib Assembly

Start Date: 7/29/2011 Start Qty: 3.00

Required Date: 8/5/2011 Req'd Qty: 3.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: 11-07-29 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4034

B

100

Weld per dwg A/R S.S. rod Batch: 114649 0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564

2- Weld bushing in rib and grind weld flush as per dwg

② PAB/EL 11/09/19

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

② 11-09-19 ②

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

Sutoris

② ②

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Page 2

Item ID: D4034-041

Accept



Setup Start



Revision ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

130

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

Cpl / PAB 11/09/19

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/2011
UMF
11-09-20

Picklist Print

Friday, July 29, 2011 8:56:54 AM

Page 1

Work Order ID: 72551

Parent Item: D4034-041

Parent Item Name: Aft Upper Rib Assembly

Start Date: 7/29/2011

Required Date: 8/5/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC IPP Rev:B as
per dwg revA 10.03.15 verified by:EC IPP Rev:C 11.01.19 AS PER
DWG REV.B DD VERF:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|----------------|--|--------------|----|--|--|-----|------|---------|---|---|--|--------------------------|--|
| D4034-1 Rib | | Manufactured | No | | | 100 | Each | 11.0000 | 1 | 3 | | 11/09/16 PMB 11/08/15 | |
|----------------|--|--------------|----|--|--|-----|------|---------|---|---|--|--------------------------|--|

Location

Loc Qty

Loc Code

WA

11

67334

11

| | | | | | | | | | | | | | |
|----------------|--|--------------|----|--|--|-----|------|--------|---|---|--|--------------------------|--|
| D4034-3 Rib | | Manufactured | No | | | 100 | Each | 5.0000 | 1 | 3 | | 11/09/16 PMB 11/08/15 | |
|----------------|--|--------------|----|--|--|-----|------|--------|---|---|--|--------------------------|--|

Location

Loc Qty

Loc Code

WA

5

58408

0

67338

2

72253

3

| | | | | | | | | | | | | | |
|-----------------|--|--------------|----|--|--|-----|------|--------|---|---|--|--------------------------|--|
| D4021-7 Hoop | | Manufactured | No | | | 100 | Each | 1.0000 | 1 | 3 | | 11/08/15 PMB 11/02/19 | |
|-----------------|--|--------------|----|--|--|-----|------|--------|---|---|--|--------------------------|--|

Location

Loc Qty

Loc Code

WA005

1

71743

1

B 72252

— 2

Picklist Print

Friday, July 29, 2011 8:56:54 AM

Page 2

Work Order ID: 72551



Parent Item: D4034-041



Parent Item Name: Aft Upper Rib Assembly

Start Date: 7/29/2011

Required Date: 8/5/2011

Start Qty: 3.00

Required Qty: 3.00

D4021-9

Manufactured No

100

Each

126.0000

4

12



Bushing

pmf 11/09/19

Location

Loc Qty

Loc Code

WA

124

70333

60

72482

64

WA005

2

66437

2

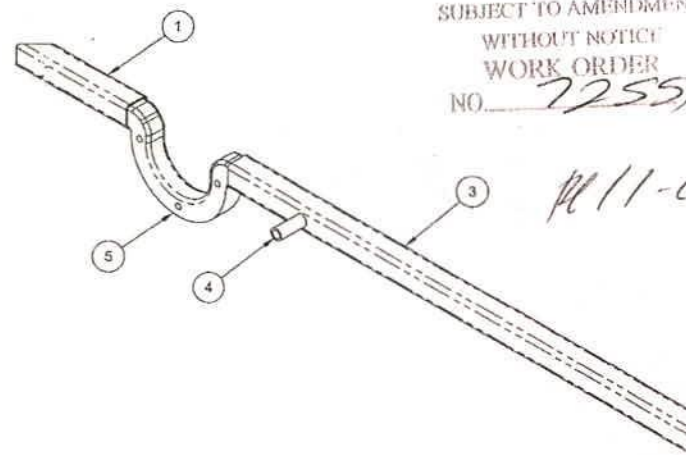
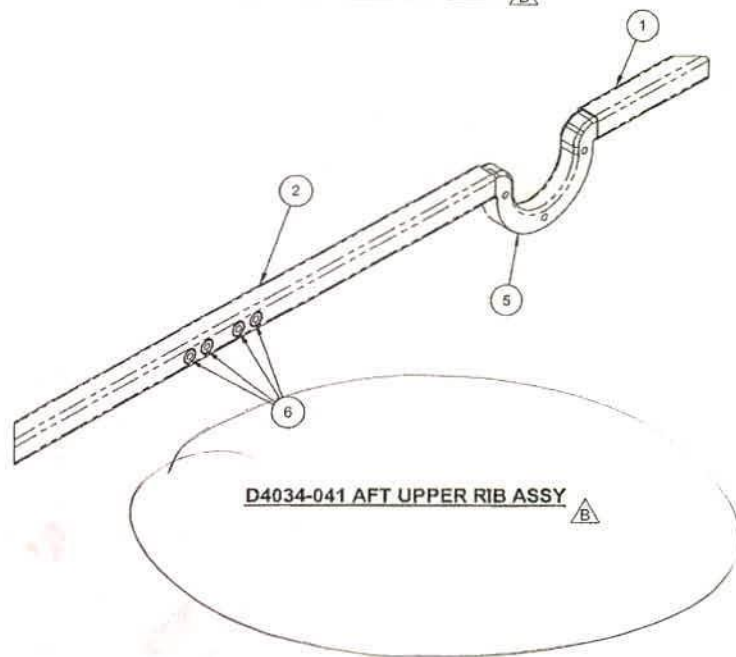
8

Friday, July 29, 2011 8:56:54 AM

Shop Packet Print

Page 2

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|--------------------|
| | X | | D4034-041 | AFT UPPER RIB ASSY |
| | | X | D4034-043 | FWD UPPER RIB ASSY |
| 1 | 1 | 1 | D4034-1 | RIB |
| 2 | 1 | | D4034-3 | RIB |
| 3 | | 1 | D4034-5 | RIB |
| 4 | | 1 | D2327-3 | SPACER BUSHING |
| 5 | 1 | 1 | D4021-7 | HOOP |
| 6 | 4 | | D4021-9 | BUSHING |



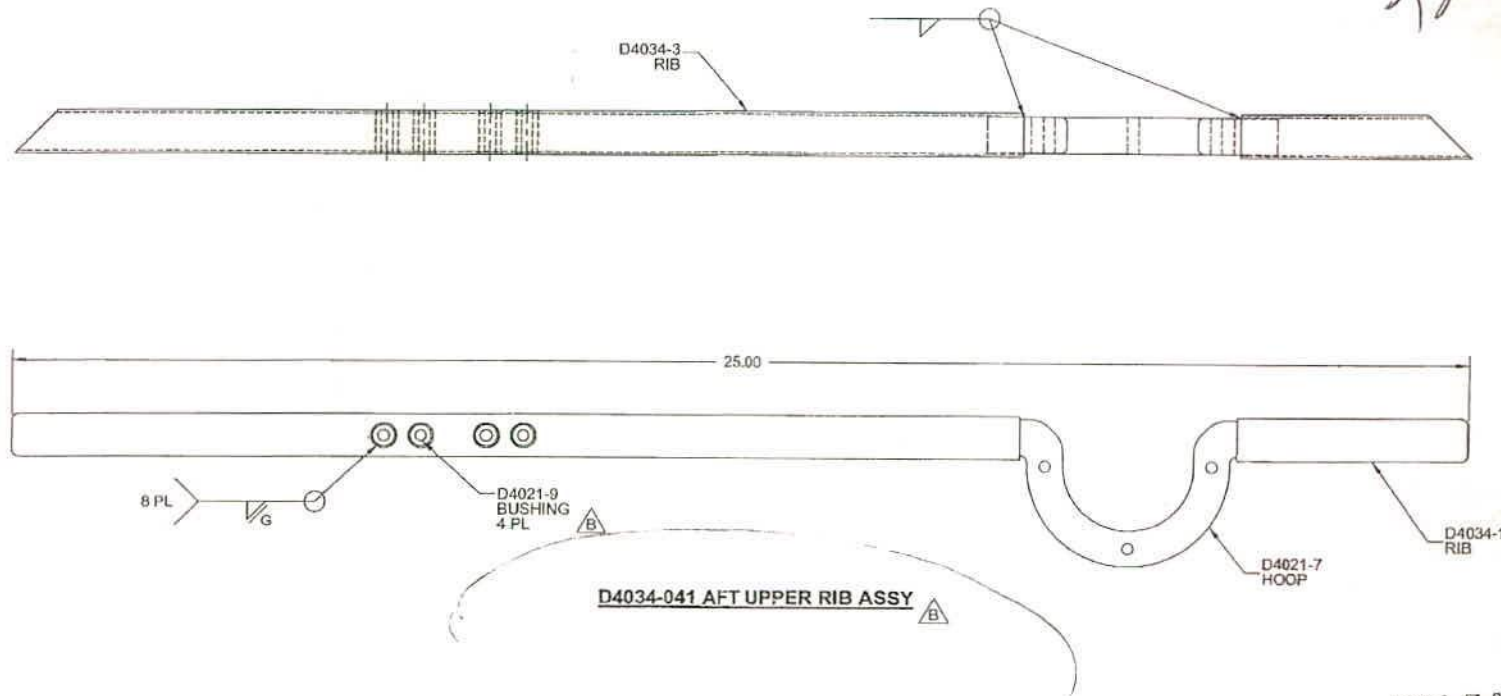
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72551

11-07-29

RELEASED
2011-01-18
MB

| | | | |
|------------|---------------------------------------|---|--------------|
| REV. | DESCRIPTION | BY | DATE |
| B | ADDITIONAL HOLES ADDED ON D4034-3 RIB | SC | 10.12.20 |
| A | NEW ISSUE | AJS | 10.03.04 |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | SC | DRAWING NO. | REV. B |
| MFG. APPR. | SC | D4034 | SHEET 1 OF 4 |
| APPROVED | SC | TITLE | SCALE |
| DE APPR. | SC | UPPER RIB ASSY, BASKET BASE | NTS |
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12551



D4034-041 AFT UPPER RIB ASSY

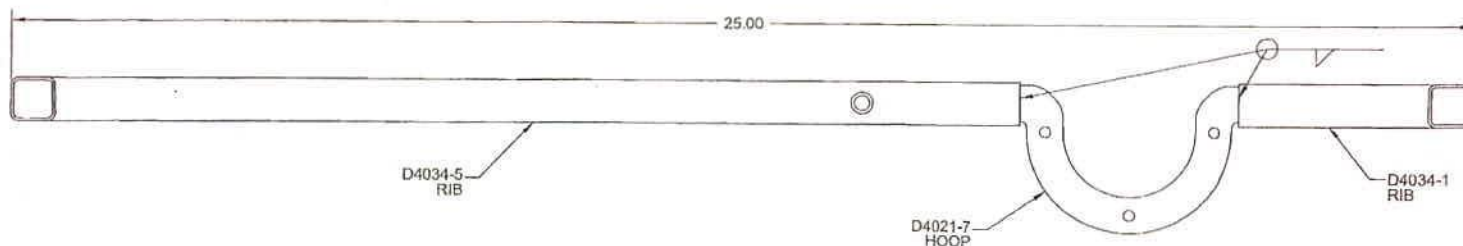
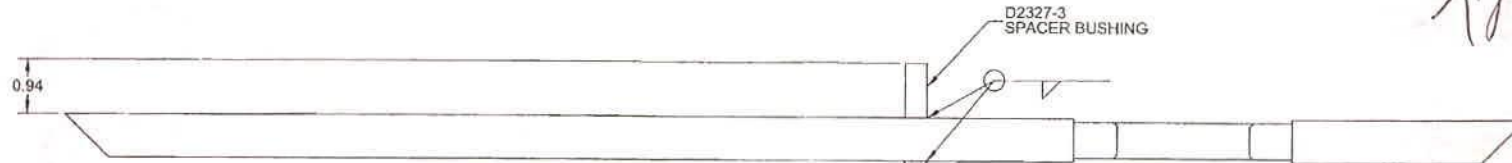
RELEASED
2011-01-38

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.61 lbs
 - 8) WELD PER DART QSI 004

| | | | |
|------------|----------|--|--------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | JS | DRAWING NO. D4034 | REV. B |
| MFG. APPR. | JS | SHEET 2 OF 4 | |
| APPROVED | JS | TITLE | SCALE |
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8 7 6 5 4 3 2 1


17591



D4034-043 FWD UPPER RIB ASSY

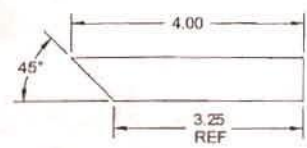
RELEASED
2011-01-18

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.58 lbs
 - 8) WELD PER DART QSI 604

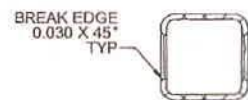
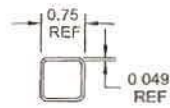
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|--|---|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | SC | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 15 | DRAWING NO. | REV. B |
| MFG. APPR. |  | D4034 | SHEET 3 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. | | UPPER RIB ASSY, BASKET BASE | NTS |
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8 7 6 5 4 3 2 1

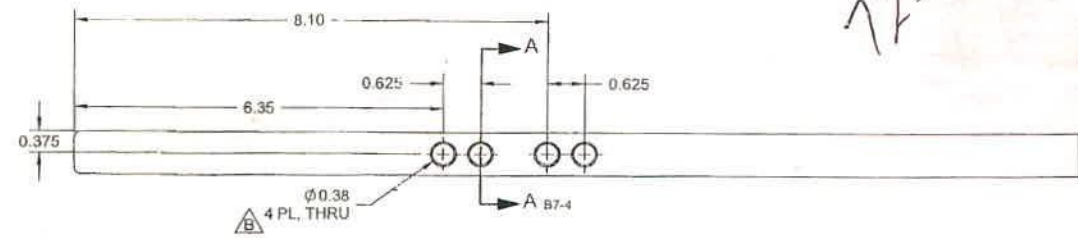
72591



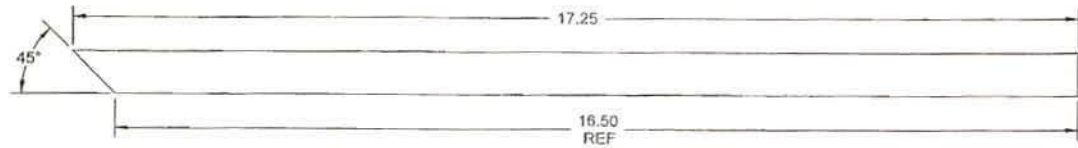
D4034-1 RIB



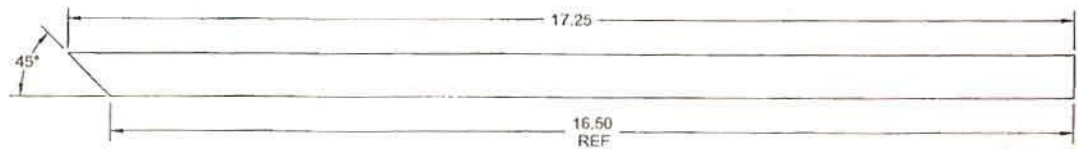
SECTION A-A D4-4



D4034-3 RIB



D4034-5 RIB



RELEASED
2011-01-10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | SC | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D4034 | SHEET 4 OF 4 |
| APPROVED | | TITLE | SCALE |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries